

# Work Order ID 114468

March-06-14 10:07:38 AM

**\*114468\***

Page 1

Item ID: D350-602-013

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Utility-Pod™ LH

Stop

**\*NS2\***

Start Date: 3/06/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/10/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: W

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

To

Draw Nbr	Revision Nbr
D2202	G
D2694	I
DSI 9515	B

100

Document Control

0.00

**\*100\***

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP

D350-602-013

CHG002

**MAR 12 2014**

<b>DART</b> AEROSPACE		1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 4K7 TEL 1-613-632-5201 www.dartaerospace.com	
PATENT	N/A	CHG	CHG006
P/N	D350-602-011	STC	SH93'97
DESC	Heli-Utility-Pod	STC	SR01144NY
LOT	B104433	STC	
MODEL	AS350	STC	
TC APPROVAL # 09-89		MADE IN CANADA	
		D2729-4	



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RTV SEALANT B.126.27

SUPPRESSED BY D2202 REV. 6

14.03.02

D2202 REV. G

114.07.0

**Work Order ID 114468****\*114468\***

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March-06-14 10:07:38 AM

Item ID: D350-602-013

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Utility-Pod™ LH

Stop **\*NS2\***

Start Date: 3/06/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/10/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
160	Pick Kit	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT IS IN BOX								
170	QC4- 100% Inspect kits for completeness	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

MAR 12 2014

**Work Order ID 114468**

March-06-14 10:07:38 AM

**\*114468\***

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Item ID: D350-602-013

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Utility-Pod™ LH

Start Date: 3/06/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/10/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

**\*180\***

Packaging

Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP AS  
D350-602-013, USING NEW B/N  
Identify and pack for shipping as per PPP D350-602-013  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_

DAS  
6  
9-89

MAR 12 2014

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

MC 14-0372

U140312

# Picklist Print

March-06-14 10:06:36 AM

Page 1

Work Order ID: 114468

**\*114468\***

Parent Item: D350-602-013

**\*D350-602-013\***

Parent Item Name: Heli-Utility-Pod™ LH

Start Date: 3/06/14

Required Date: 3/10/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-05-01 JLM IPP Rev:B Added D3495-1 06-05-17  
JLM IPP RevC: add route seq DD 10.01.07 verified  
by:EC IPP REV:D AS PER ECN 10-558 JLM 10-04-27  
VERIFIED BY:DD  
IPP Rev:C 09-02-03 update dwg rev's DD verified by:EC IPP Rev:D  
add D2202-1 and D2202-5 DD 10.04.07 verified:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD64ABS		Purchased	No				Each	146.0000		42			
<b>*AD64ABS*</b>										**		DAS 26 14-3-11 9-89	
Pop Rivet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST278			146						
					123969		46						
					125147		100						
									142x				
AD66ABS		Purchased	No				Each	230.0000		2			
<b>*AD66ABS*</b>										**		DAS 26 14-3-11 9-89	
Pop Rivet													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST278			230						
					112784		230						
									2x				
D3048-1		Manufactured	No				Each	5.0000		1			
<b>*D3048-1*</b>										**		BT 14-03-06	
Doubler													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CA			5						
					100618		4						
					107527		1		x1				

# Picklist Print

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Page 2

Work Order ID: 114468

**\*114468\***

Parent Item: D350-602-013

**\*D350-602-013\***

Parent Item Name: Heli-Utility-Pod™ LH

Start Date: 3/06/14

Required Date: 3/10/14

Start Qty: 1.00

Required Qty: 1.00

D350-602-011

Manufactured No

Each

2.0000

1

**\*D350-602-011\***

**\*\***

Heli-Utility-Pod™ (Fits LH or RH)

RT 14-03-06

Location

Loc Qty

Loc Code

FG110

2

104433

1

93087

1

X 1

FG-778150-550-ROL

Purchased

No

sf

2,492.000

2

**\*FG-778150-550-ROL \***

**\*\***

7781 9oz Glass 50x125yd

RT 14-03-06

Location

Loc Qty

Loc Code

CA

2492

M127570

929

M127701

1563

X ~~40~~ 40 sf



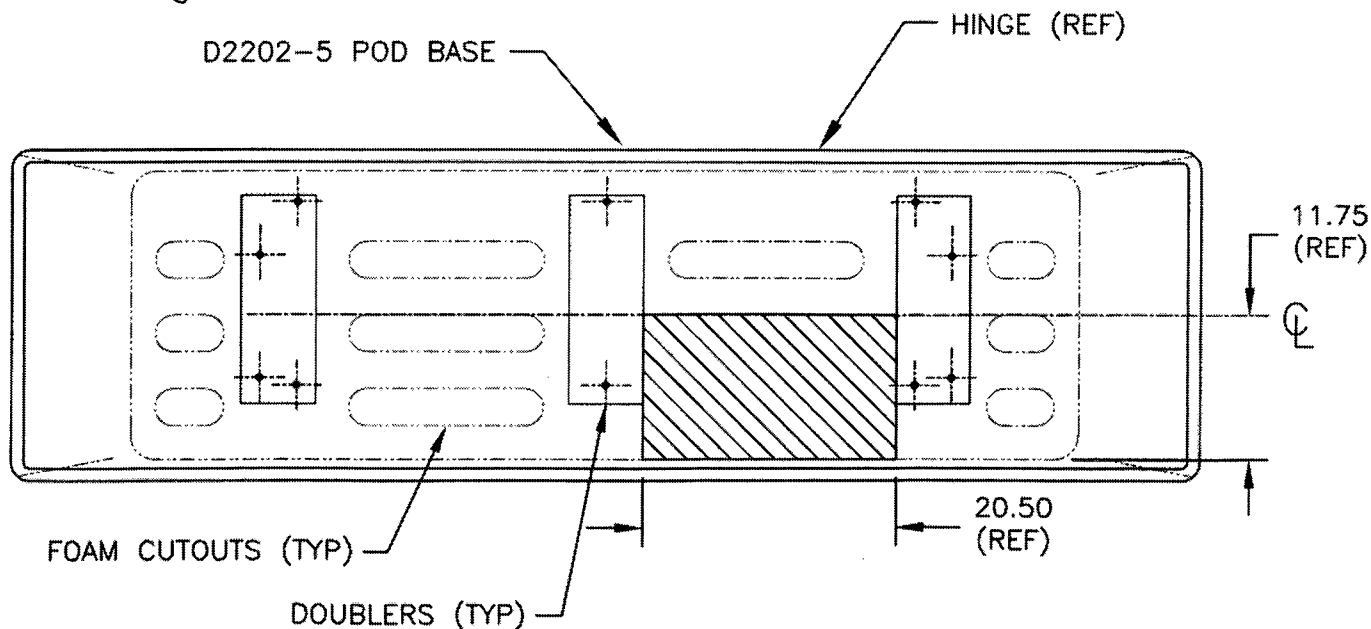
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3322	REV. A SHEET 1 OF 1
DATE 04.09.26		TITLE POD ASSEMBLY	SCALE 1:15
A	04.09.26	NEW ISSUE	

RELEASED  
04.10.29 *[Signature]*

### D3322-041/-042 POD ASSEMBLY

- 1) THE D3322-041/-042 POD ASSEMBLIES ARE THE SAME AS THE D2694 POD ASSEMBLIES, EXCEPT THE D2202-3 POD BASE IS REPLACED WITH THE D2202-5 POD BASE

*see 110968*

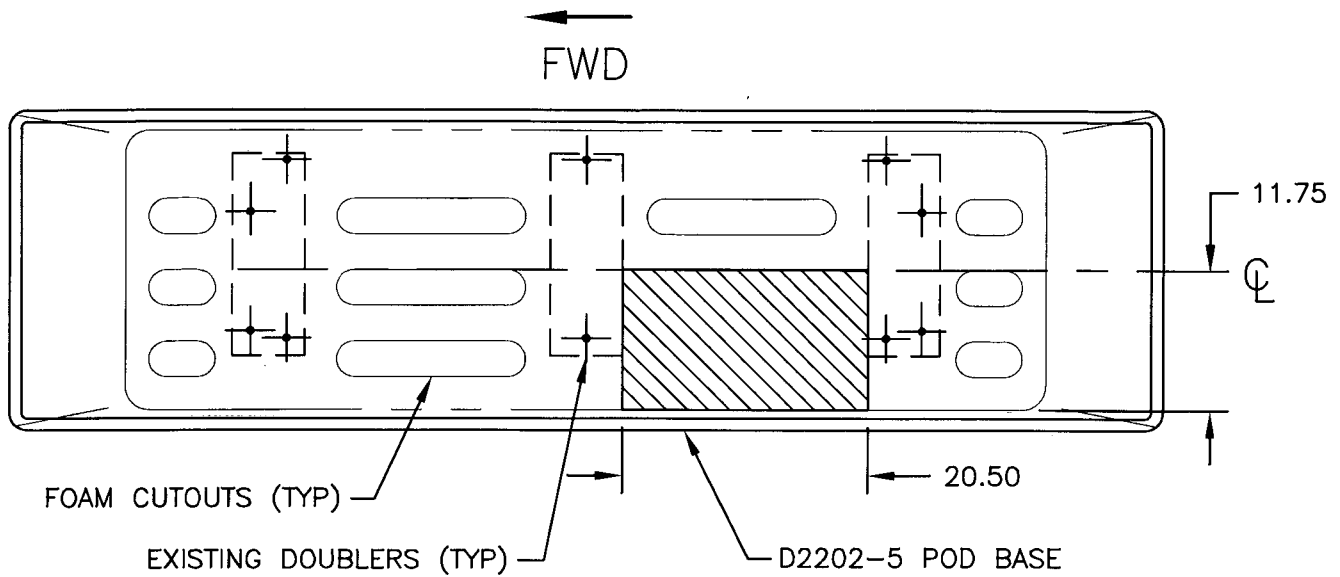


D3322-041 POD ASSEMBLY (SHOWN)  
D3322-042 POD ASSEMBLY (OPPOSITE)

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**Figure 4** – Modification to D350-602-013/-014 pods (-013 LH shown, -014 RH opposite)  
View looking down

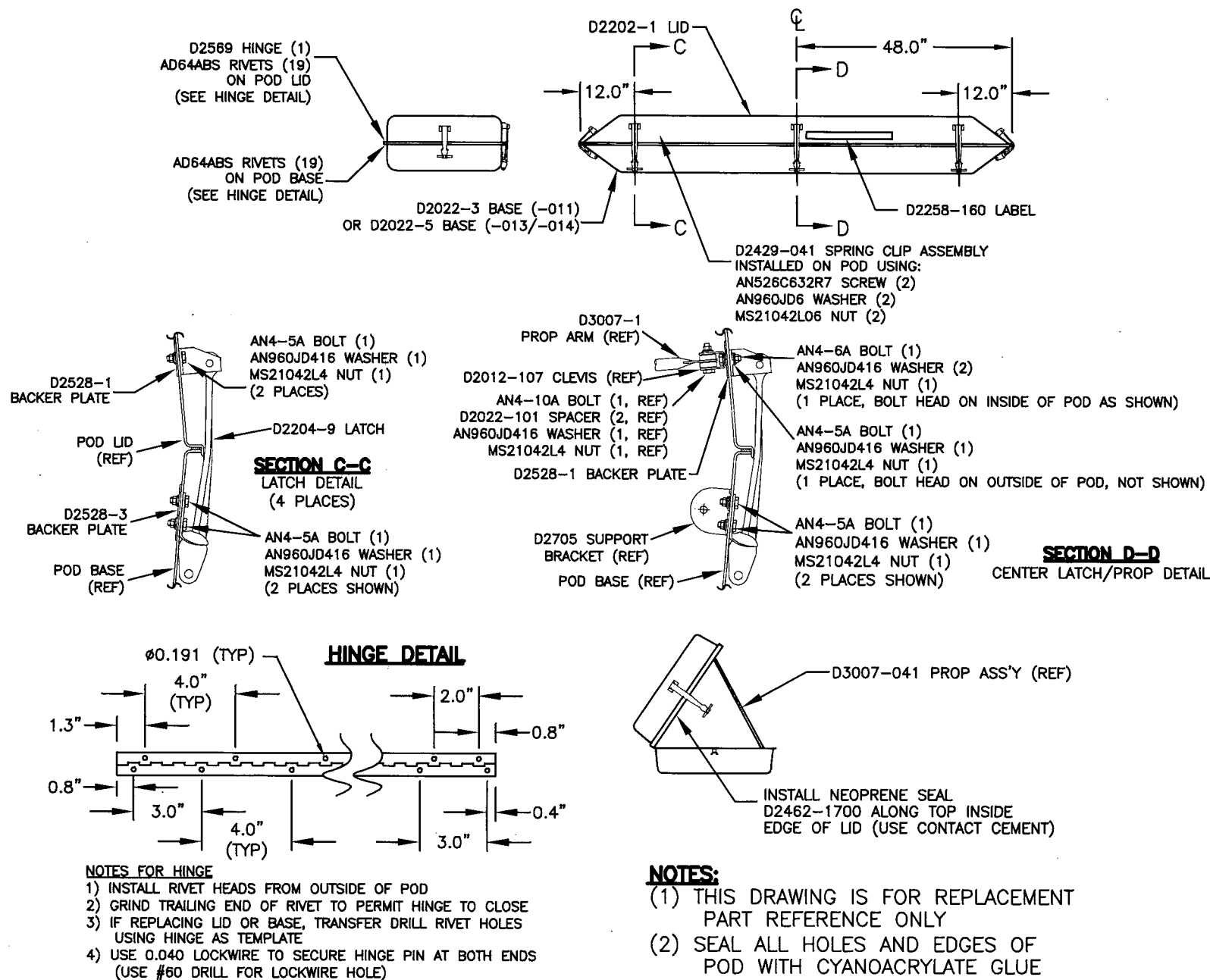


Figure 5 – Replacement Parts

**NOTES:**

## 1) MATERIALS:

RESIN: EPOCAST 50-A/9816,  
OR DERAKANE 470-36/411/510A40

FOAM: A500 CORE CELL,  
OR DIVINYCELL,  
OR AIREX,  
0.38 THICK (3/8 FOAM)

FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)

2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2  
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.  
LAMINATION SCHEDULE PER THIS DRAWING.

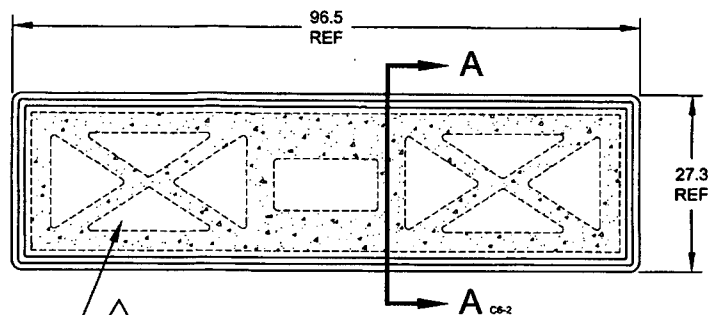
9) PEEL PLY ALL SURFACES.

RELEASED  
2010-10-28

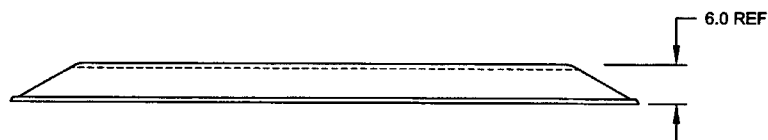
G	REFORMAT DRAWING TO CURRENT STANDARDS: D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEC 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034	RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04
B	ADD DOUBLERS AND HOLES	-	93.10.27
A	NEW ISSUE	-	93.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 1 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	11	UTILITY POD LID AND BASE	NTS
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SEE  
DETAIL B  
A6-2

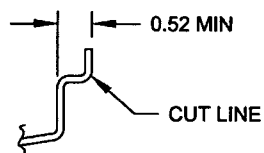
**SECTION A-A** C3-2



**G**  
D2202-101 FOAM CORE,  
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



**D2202-1 LID**  
(MOLD DT8002)



**DETAIL B**  
SCALE 10X D6-2

**MAIN LAYUP**  
9oz SATIN  
9oz SATIN  
5oz KEVLAR  
**G** D2202-101 FOAM CORE  
5oz KEVLAR  
9oz SATIN

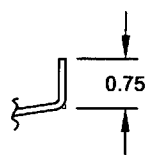
**RELEASED**  
2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
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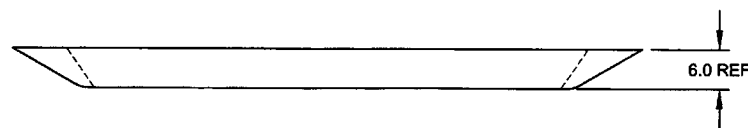
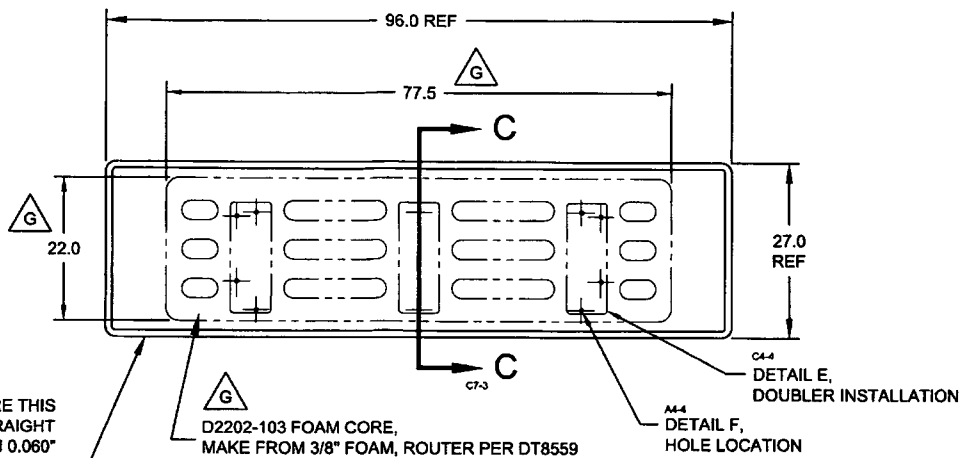
SEE  
DETAIL D  
B7-3

**SECTION C-C** C4-3

ENSURE THIS  
EDGE IS STRAIGHT  
WITHIN 0.060"  
AFTER TRIMMING



**DETAIL D**  
SCALE 10X  
D7-3



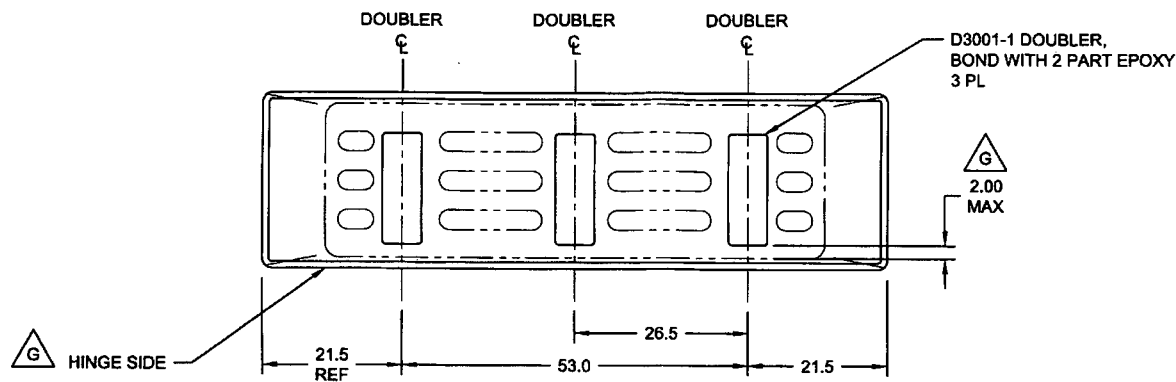
**D2202-3 BASE**  
(MOLD DT8002)

**MAIN LAYUP**

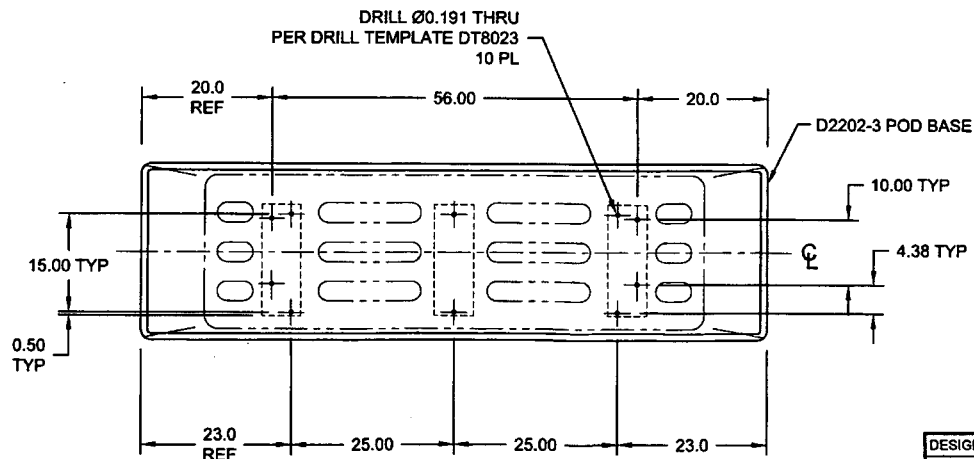
9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-103 FOAM CORE  
5oz KEVLAR  
5oz KEVLAR  
9oz SATIN

**RELEASED**  
2010-10-28

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
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**DETAIL E: INSTALLATION OF D3001-1 DOUBLERS** C3-3



**DETAIL F: HOLE DRILLING** C3-3  
(AFTER DOUBLER INSTALLATION)

**RELEASED**  
2010-10-28  
JM

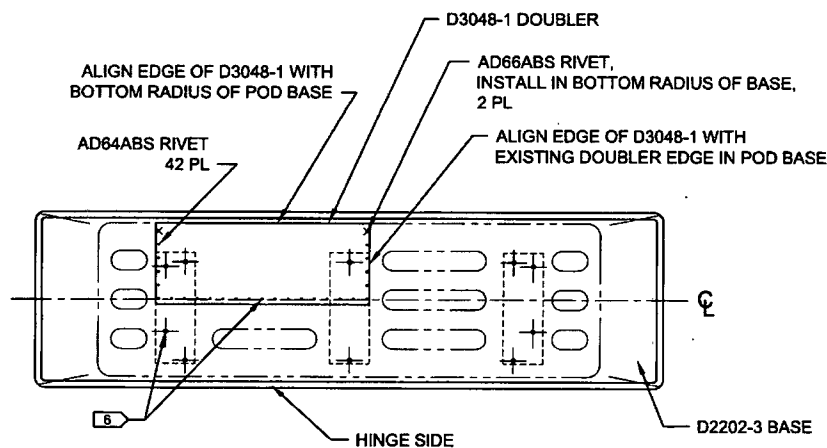
DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 4 OF 5
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**NOTES : TO MAKE A D2202-5-6 BASE (FOR D3048-013-014) FROM A D2202-3 BASE**

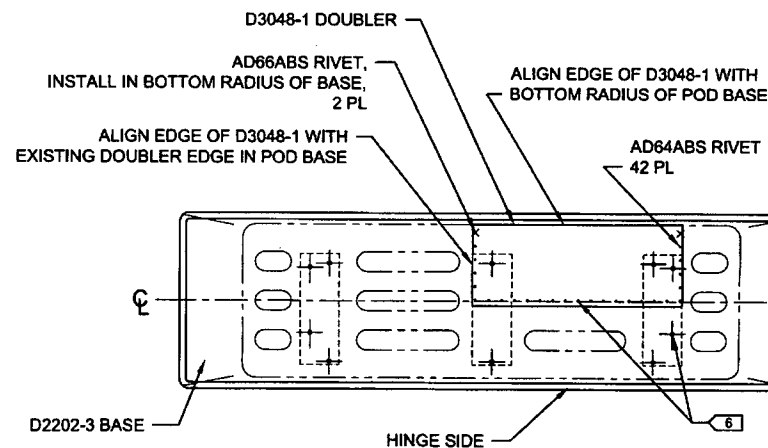
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

**PART LIST:**

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



**D2202-5 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)



**D2202-6 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)

DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 5 OF 5
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